Tapered Steel Tube Specifications

Description

Tapered steel tubes shall be in accordance with the details of these specifications.

Materials

General

All steel shall be melted and manufactured in the USA. Silicon content for tapered tubes shall be less than 0.06%. All tubes shall be manufactured in the USA in an AISC certified fabrication facility for Steel Building and Bridge Metal Components.

Tapered tubes

Tapered steel tube shaft shall be formed from single trapezoid using a single seam. The seam shall be welded by the high frequency electrical resistance process. The shaft shall then be formed round using a coining process. The shaft shall have a taper rate of 0.1375 in. per foot. Steel material used shall be produced from weldable, high grade steel with a minimum yield of 55,000 psi after fabrication. Finished tube shall be certified as ASTM A595, A572, A1011 or equal. Specified thicknesses may be 11ga., 7ga., 3ga., 0ga., ⅜ in. or ½ in.

Welded longitudinal seams

All longitudinal seam welds shall be performed by a high frequency electrical resistance welding machine. Welding procedures are to be tested in accordance to AWS D1.1 welding code. Longitudinal seam welds are to be scarfed on the outside of the tube.

Tube diameters

Please discuss your required tube diameters and thicknesses with your Pole Products contact to determine what sizes best fit your needs.

Finish

Finish shall be black (as received material).

Shipment of fabricated tapered steel tubes

Fabricated tapered steel tubes shall be shipped complete via reliable carrier stacked safely and securely to preserve the aesthetic integrity of product. The poles may also be picked up, if preferred.

poleproducts@nov.com

ameronpoles.com